

SPLIT

DART AEROSPACE LTD	Work Order:	22518
Description: Folding Step Weldment LH	Part Number:	D3388-041
Dwg: D3388 Rev. A	Qty:	20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty												
1	DC	Issue Traveler Dwg not required	JS	05.02.23	20												
2	GA	Cut D2622-120C extrusion 85.15" long as per Dwg D3388 Batch: <u>B21640</u>	PD	05-03-07	10												
3	GA	Deburr and bevel ends for welding	PD	05-03-07	10												
4	WA	Weld arms and end caps as per Dwg D3388. Inspect for foreign objects as per QSI 024. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2734</td><td>End Cap</td><td><u>320757</u></td></tr><tr><td>2</td><td>D3387-041</td><td>Arm</td><td><u>B22527</u></td></tr></table>	Qty	Part Number	Description	Batch	2	D2734	End Cap	<u>320757</u>	2	D3387-041	Arm	<u>B22527</u>	LE	05-06-1	10
Qty	Part Number	Description	Batch														
2	D2734	End Cap	<u>320757</u>														
2	D3387-041	Arm	<u>B22527</u>														
5	GA	Grind end cap welds flush	LE	05-06-2	10												
6	QC9/5	Inspect weld and work to Step 5	Z	05-06-08	10												
7	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05-06-09	10												
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	FC	05-06-27	10												
9	FP	Wing Walk as per Dwg D3388 and QSI 005 4.4	MM	05-06-28	10												
10	QC3	Inspect Powder Coat and Wing Walk	BD	05-06-28	10												
11	ST	Identify and Stock	SB	05/06/28	10												
12	AC	Cost / part: <u>284.90</u>	S	05-08-26	10												
13	DC	Close W/O <u>208.54</u> Inspect Level 21	CS	05-08-29	10												

Rev	Date	Change	Revised By	Approved
A	05.02.22	New Issue	KJ/JLM	

RELEASED
05-02-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

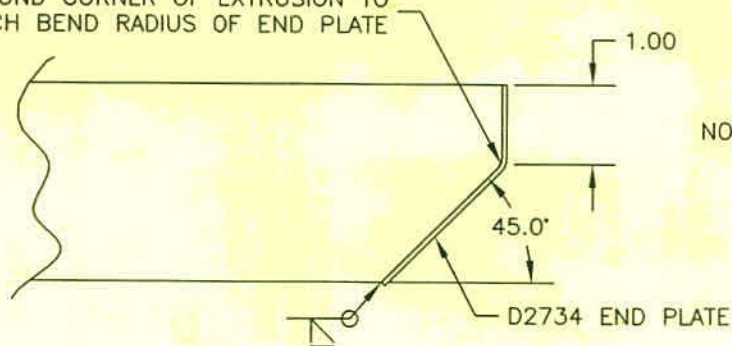
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DP Date: 05/08/24

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

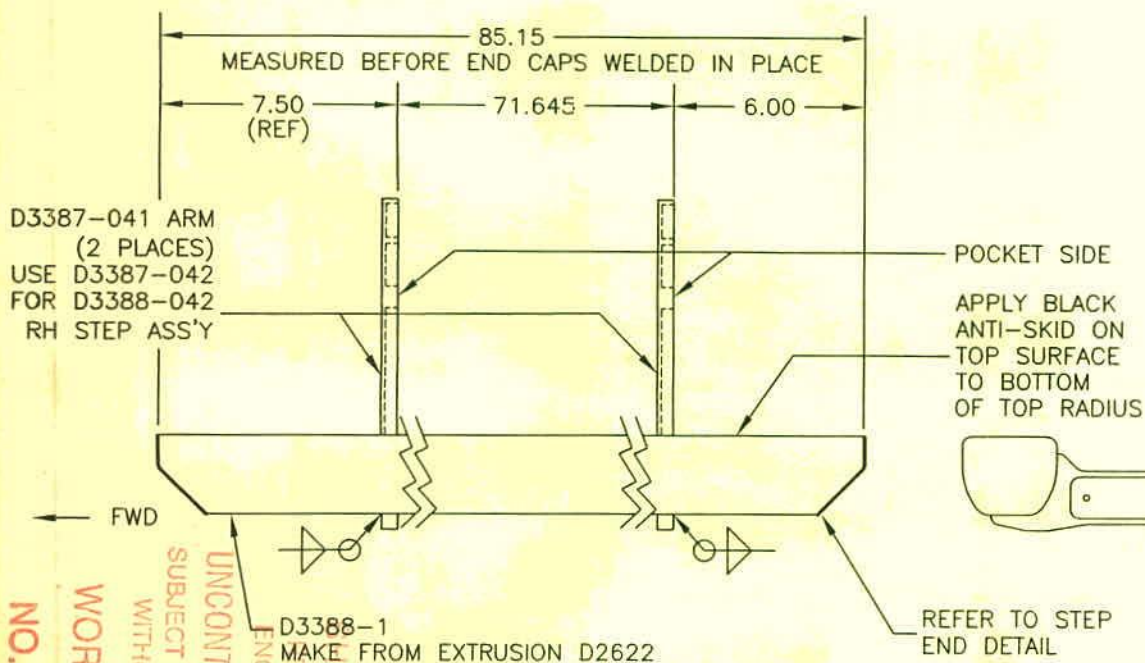
PRELIMINARY ISSUE

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



NOTE: ALL WELDS SHALL BE 100%
VISUALLY INSPECTED BY A
QUALIFIED INSPECTOR PER
DART QSI 004

TYPICAL STEP END DETAIL
NOT TO SCALE



D3388-041 LH STEP ASSEMBLY (SHOWN)
D3388-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	APPROVED	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3388	SHEET 1 OF 1
05.01.20		TITLE	SCALE
		STEP WELDMENT	NTS
A	05.01.20	NEW ISSUE	

WORK ORDER
NO. 22518

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 22, 2005
03:39 pm

Work Order No : 0022518
Project Name : D3388-041
Project For : WK513
Work Order Type : Main
Main WO Number :
House Part Number : D3388-041
Description : Step Weldment LH
Manufactured : No
Amount Req'd : *820*
Amount Done : *0*
Start Date : 02-22-05
Est Finish Date : 03-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00